

❖ Product Description

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| I. Gas shielded, rutile type FCW wire | IV. Uniform and good weld bead appearance |
| II. Low fumes, very less spatter and slag removed easily | V. Typical 18%Cr-12%Ni-2Mo weld deposit |
| III. Excellent resistance to intergranular corrosion | VI. Radiographic weld quality |

❖ Range of Application

- | | |
|--|---|
| I. Extremely good for welding of 18% Cr, 12% Ni & 2.50% Mo steel | II. For use in chemical plant, paint, pulp paper & textile industries for welding AISE 316 & 317L steels. |
|--|---|

❖ Classification

- AWS/SFA 5.22 E316LT1

❖ % Chemical Composition

| Type of Wire | | C | Mn | Si | S | P | Mo | Cr | Ni | Cu |
|--------------|-----|------|------|-----|------|------|-----|------|------|------|
| E316LT1 | Min | - | 0.50 | - | - | - | 2.0 | 17.0 | 11.0 | - |
| | Max | 0.04 | 2.50 | 1.0 | 0.03 | 0.04 | 3.0 | 20.0 | 14.0 | 0.75 |

❖ Mechanical Properties of all weld metal

| Condition | UTS, MPa (Min) | YS, MPa (Min) | % Elongation | Charphy "v" Notch Impact @ -30°C |
|-----------|----------------|---------------|--------------|----------------------------------|
| PWHT | 485 | - | 30 | - |

❖ Wire Size & Welding Position

- | | |
|----------------------------|-------------------------------|
| • Diameter in mm- 1.2, 1.6 | • Weld Position- All position |
|----------------------------|-------------------------------|

❖ Current & Gas Flow

- DCEP; 18-25lit/min

❖ Packaging

- Standard packaging in 15kg Spool form

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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